



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3210-1
Job Sheet 180314



Part No: D3210-1

Job Qty: 4 ea

Part Name: Doubler For Interior Window -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now On Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Waterjet		SC 18/08/19
100	Waterjet	4 pcs	7/20/18	7/20/18	0.00	0.96	Waterjet1		SC 18/08/19
120	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC8		38
130	Small Fab	4 pcs	7/20/18	7/20/18	0.00	0.00	Small Fab-3	N/A	9-89
140	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
150	HandFinish	4 pcs	7/20/18	7/20/18	0.00	0.28	HandFinish1		SA 18-09-10
155	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2		BL 18-09-10
160	Powdercoat	4 pcs	7/20/18	7/20/18	0.00	0.13	Powdercoat4		BL 18-09-10
170	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC3		38 DAS
180	Packaging	4 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1	SEP 14 2018	6
190	QC21-SA	4 Ea	7/20/18	7/20/18	0.00	0.00	QC21		DAS 9-89

Part Op 100 - 1-Cut as per Dwg D3210

Descriptions: 130 - Deburr

160 - START TIME: 2:10 OUT: 3:20 FINISH: 2:40 M138839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	6.8000 sf (1.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.080	7	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.141inches + 0.005 - 0.000	0.146 0.141	0.141	
2	Doubler	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
3	Doubler	3.857inches ± 0.010	3.867 3.847	3,860	
4	Doubler	17.750inches ± 0.010	17.760 17.740	17,752	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐												
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐												
Finishing ☐	Rec/Store/Packaging ☐	Other ☐												
Composite ☐	Supplier ☐													
		MRB (QSI042) Approval												
		Disposition												
		Completed By												
		Lead hand / Supervisor Approval Verification												
		QC / QA Coordinator Approval												

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 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 09/01/18

Container No: S107515
 Part: D3210-1
 Job No: 180314
 Serial No/Batch: S107515
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Environr
 De:
 Doc/D
 Equip/Tool
 Handling/Pre
 Material
 Internal Transport
 Tribal Knowledge
 LOA
 Substation
 Past Expiry Date
 Misidentified

DART
 AEROSPACE

CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Mislabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

Supply/ROUTE
 Broken/Damage/Defect
 Inspection Incomplete/Unqualified
 Contamination
 Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

Cracks
 Crimp/Kink/Ripple/Wave
 Cuffs
 Crushing
 Heat Treat
 Wave/Twist in Tube
 Marks/Chatter

Training
 Use for Testing
 Poor Information
 Rushing
 Product Improvement
 Process Improvement
 Manufacturing Process
 Past Due

OTHER :

5	Doubler	20.150inches $\pm$ 0.030	20.180 20.120	20,150
6	Doubler	8.500inches $\pm$ 0.010	8.510 8.490	8,505
7	Doubler	1.095inches $\pm$ 0.010	1.105 1.085	1,098
8	Doubler	0.650inches $\pm$ 0.010	0.660 0.640	0,653
9	Doubler	0.350inches $\pm$ 0.010	0.360 0.340	0,354

Plex 7/4/18 1:08 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								